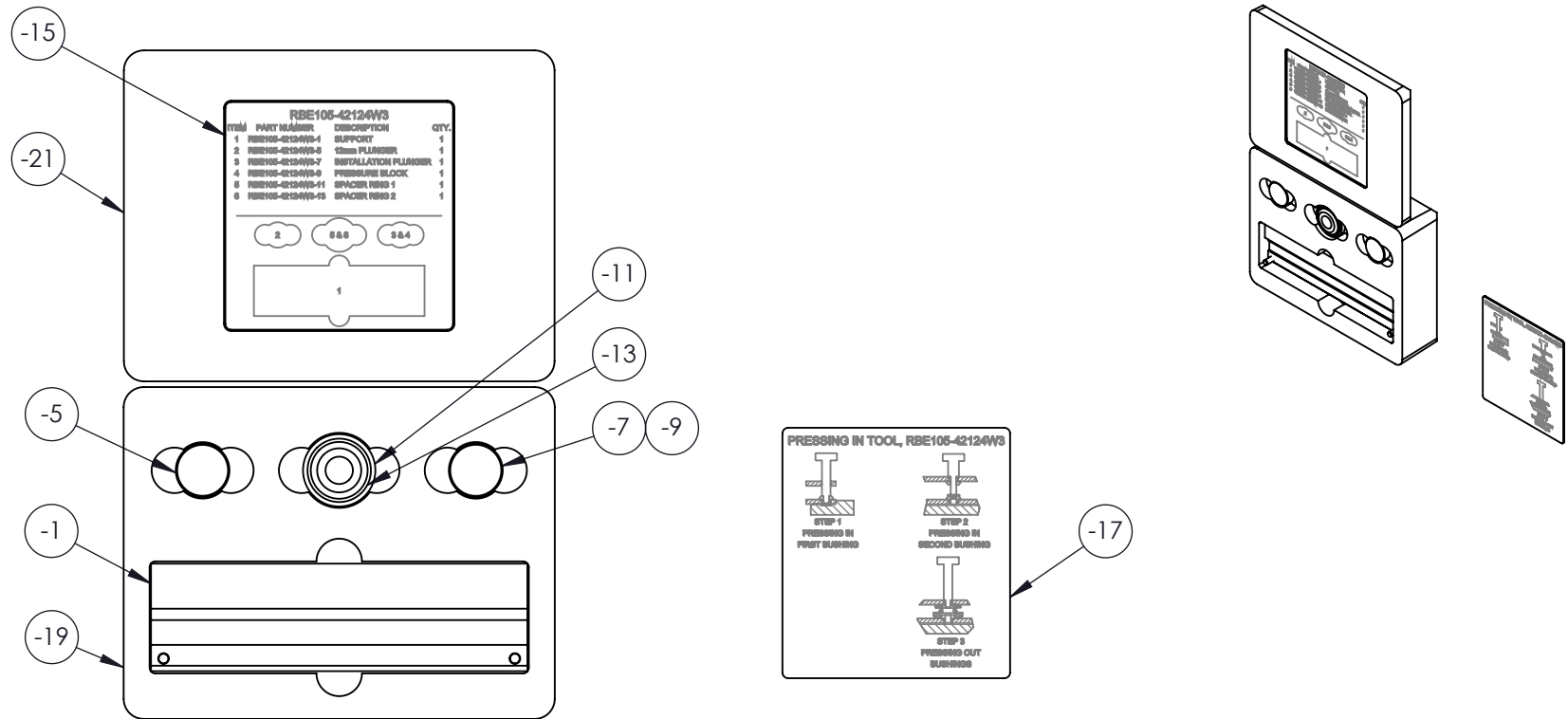


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	7/17/2017	RJC	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	SUPPORT			2
	1		-3		PLATE	4140/4142		
			-5	1	12mm PLUNGER	4140/4142		4
			-7	1	INSTALLATION PLUNGER	4140/4142		5
			-9	1	PRESSURE BLOCK	4140/4142		6
			-11	1	SPACER RING 1	4140/4142		7
			-13	1	SPACER RING 2	4140/4142		8
			-15	1	LOCATION PLACARD	PLASTIC		9
			-17	1	INSTRUCTION CARD	LAMINATED PAPER		10
		B/O	-19	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	2.90 X 7.29 X 9.47 (CASE SOLUTIONS)	11
		B/O	-21	1	TOP FOAM	ETHAFOAM 220, BLACK	1.16 X 7.27 X 9.46 (CASE SOLUTIONS)	12
	2	B/O	-23		DOWEL PIN	STEEL	M6 X 24mm (MCMMASTER-CARR #91595A458)	
		B/O	-25	1	CASE	PLASTIC	PELICAN #APP-1200-E	N/S
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S
	ASSY -1							

NOTE:
REFERENCE AIRBUS 105-42124W3.

DART AEROSPACE

TITLE
PRESSING IN TOOL

DWG NO.
RBE105-42124W3

REV
1

MAT'L
HEAT TREAT FINISH

SPEC
DRAWN BY: RJC 06/27/2017
CHECKED: DD 06/27/2017
OPPS APPR: AA 07/10/2017
QA APPR: JL 07/10/2017
APPROVED: JAG 07/19/2017

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± 5°
.X ± .1 SURFACES = 125°

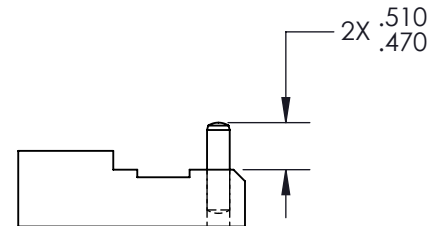
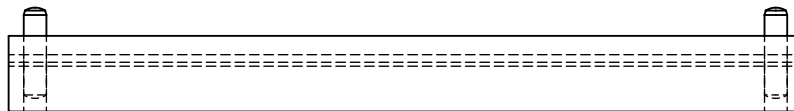
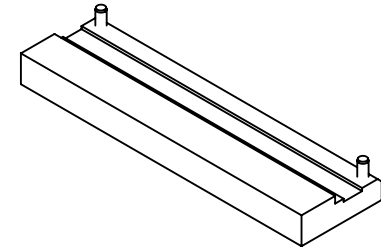
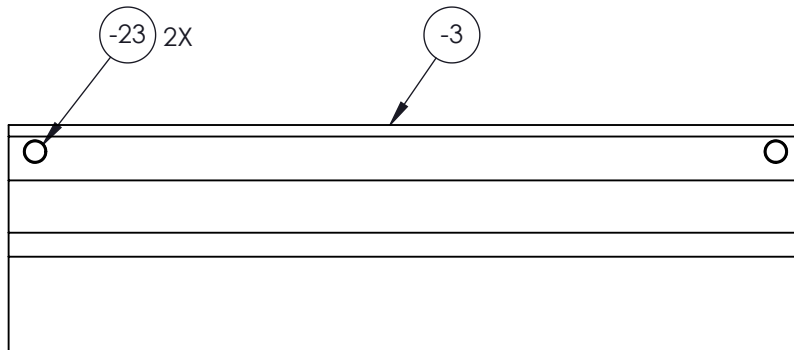
1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

USED ON MODEL
EC145, EC645, BO105, BK117

SCALE 1:4 **DATE** 6/27/2017 **SHEET** 1 OF 12

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

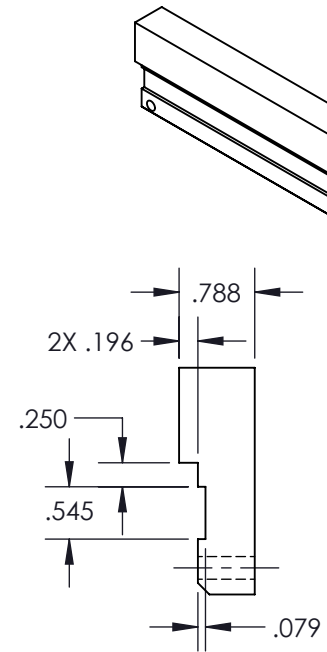
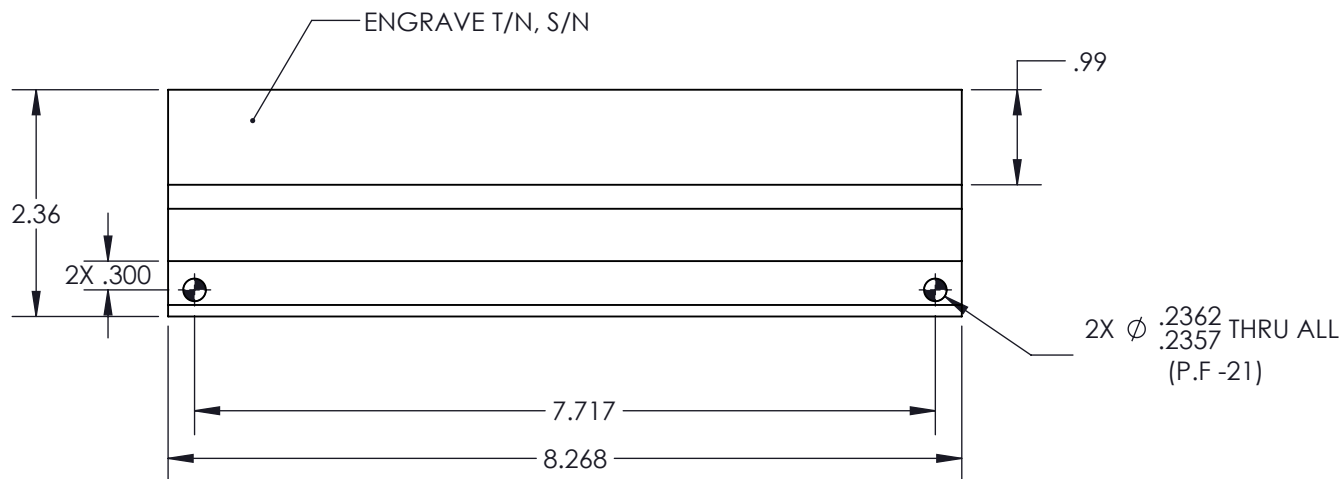


(-1)
SUPPORT

DART AEROSPACE	
TITLE PRESSING TOOL	
DWG NO. RBE105-42124W3-1	REV 1
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: RJC 06/27/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DD 06/27/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 07/10/2017	USED ON MODEL
QA APPR: JL 07/10/2017	APPROVED: JAG 07/19/2017
SCALE 1:2	DATE 6/27/2017
SHEET 2 OF 12	

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

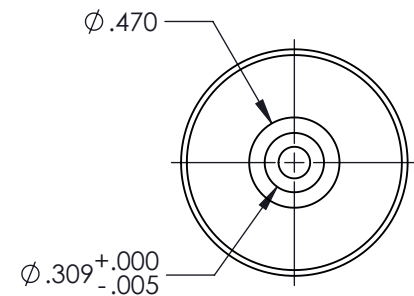
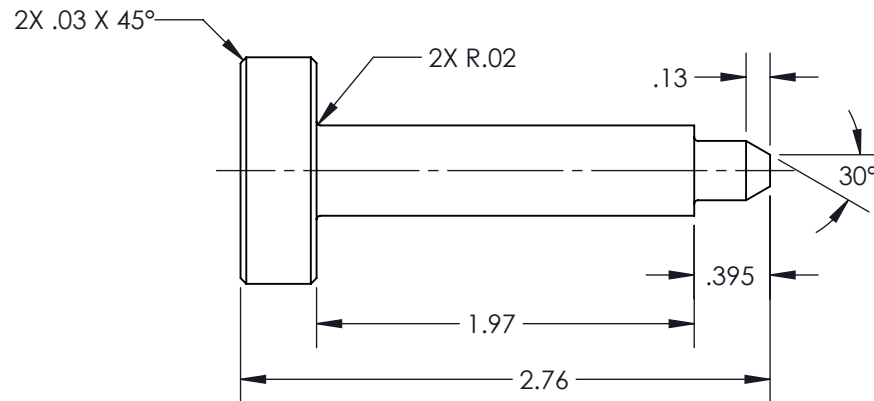
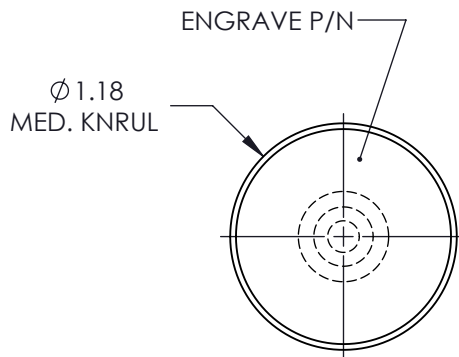
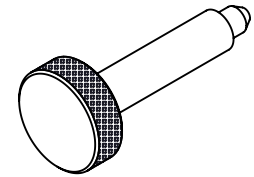


(-3)
PLATE

DART AEROSPACE	
TITLE PRESSING IN TOOL	
DWG NO. RBE105-42124W3-3	REV 1
MAT'L 4140/4142 HEAT TREAT RC 28-34 FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: RJC 06/27/2017 CHECKED: DD 06/27/2017 OPPS APPR: AA 07/10/2017 QA APPR: JL 07/10/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: JAG 07/19/2017	USED ON MODEL EC145, EC645, BO105, BK117
SCALE 1:2	DATE 6/27/2017 SHEET 3 OF 12

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



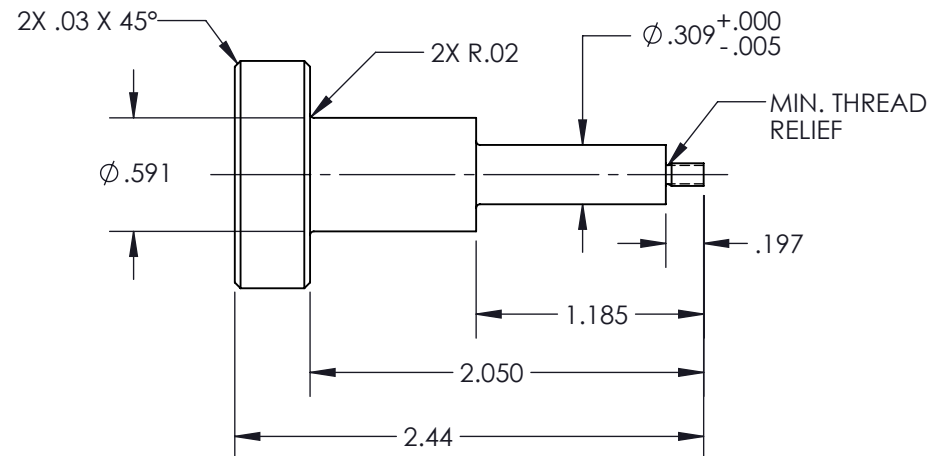
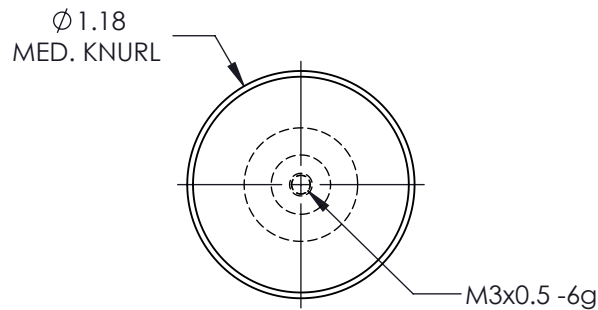
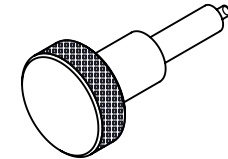
(-5)

12mm PLUNGER

DART AEROSPACE	
TITLE PRESSING IN TOOL	
DWG NO. RBE105-42124W3-5	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: RJC 06/27/2017	.X ± .1 SURFACES = 125°
CHECKED: DD 06/27/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 07/10/2017	.015 x 45° OR .015R
QA APPR: JL 07/10/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 07/19/2017	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 6/27/2017	USED ON MODEL
SHEET 4 OF 12	EC145, EC645, BO105, BK117

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



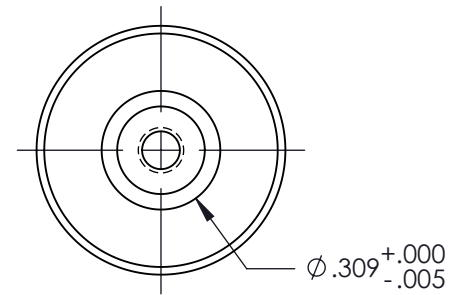
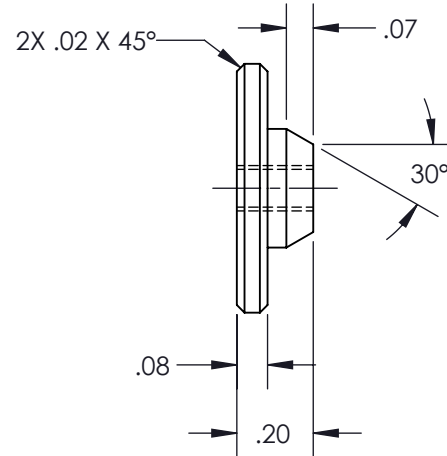
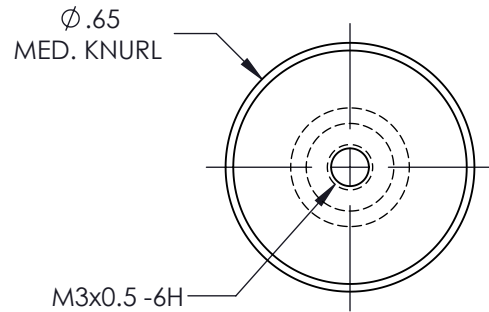
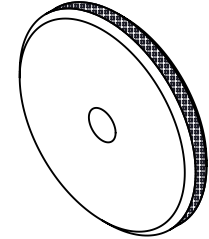
(7)

INSTALLATION PLUNGER

DART AEROSPACE	
TITLE PRESSING IN TOOL	
DWG NO. RBE105-42124W3-7	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: RJC 06/27/2017	.X ± .1 SURFACES = 125/✓
CHECKED: DD 06/27/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 07/10/2017	.015 x 45° OR .015R
QA APPR: JL 07/10/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 07/19/2017	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 6/27/2017	USED ON MODEL
SHEET 5 OF 12	EC145, EC645, BO105, BK117

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



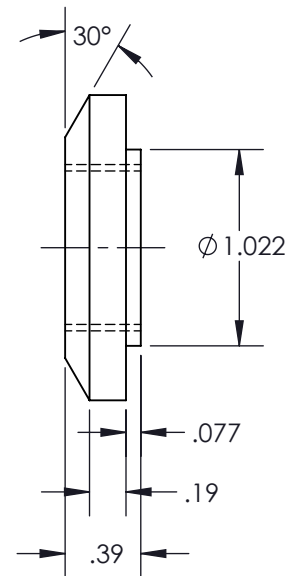
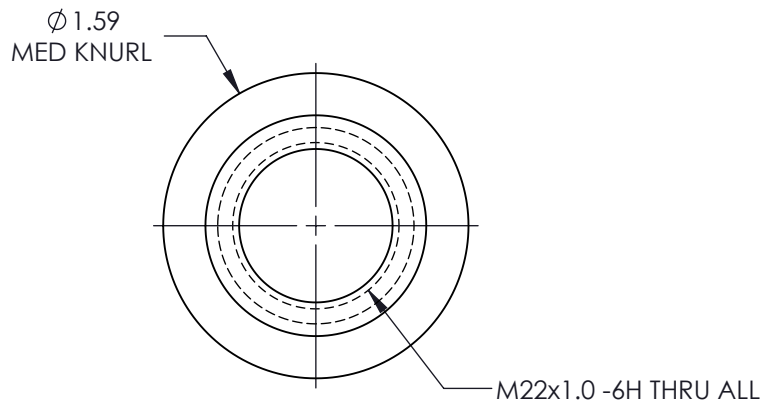
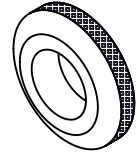
(-9)

PRESSURE BLOCK

DART AEROSPACE	
TITLE PRESSING IN TOOL	
DWG NO. RBE105-42124W3-9	REV 1
MAT'L 4140/4142 HEAT TREAT RC 28-34 FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: RJC 06/27/2017 CHECKED: DD 06/27/2017 OPPS APPR: AA 07/10/2017 QA APPR: JL 07/10/2017 APPROVED: JAG 07/19/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 2:1	DATE 6/27/2017
SHEET 6 OF 12	

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



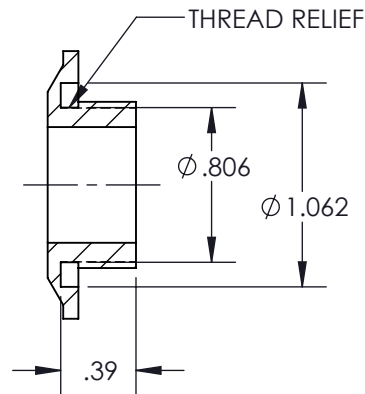
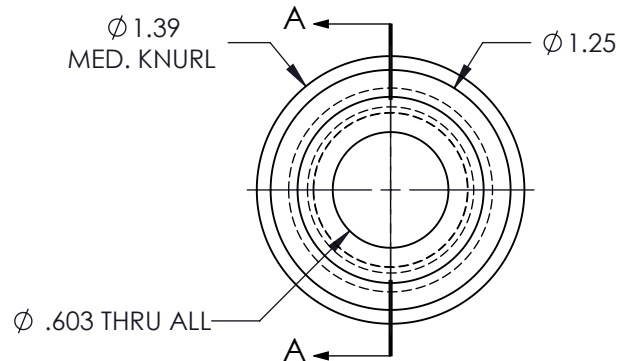
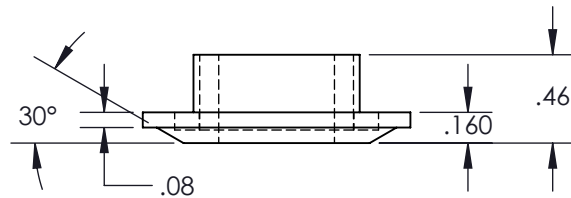
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SPACER RING 1

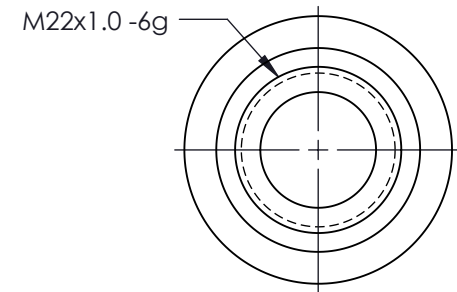
DART AEROSPACE	
TITLE PRESSING IN TOOL	
DWG NO. RBE105-42124W3-11	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: RJC 06/27/2017	1. BREAK ALL SHARP EDGES
CHECKED: DD 06/27/2017	.015 x 45° OR .015R
OPPS APPR: AA 07/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: JL 07/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: JAG 07/19/2017	USED ON MODEL
SCALE 1:1	DATE 6/27/2017
	SHEET 7 OF 12

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				APPROVED



SECTION A-A



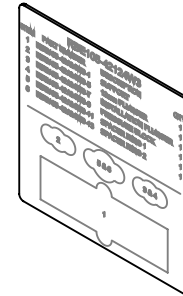
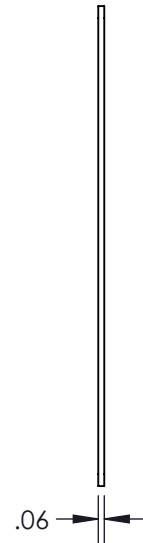
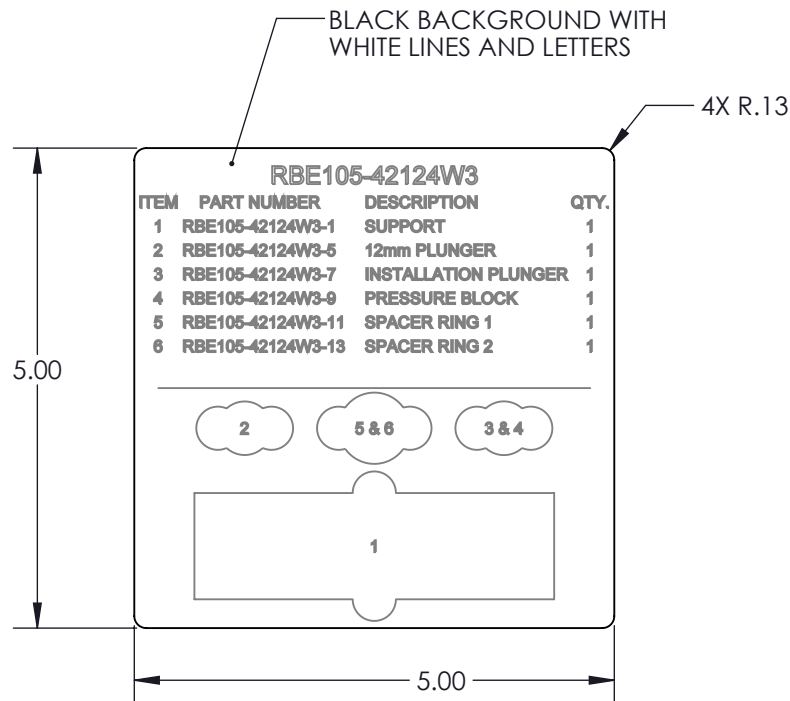
(13)

SPACER RING 2

DART AEROSPACE	
TITLE PRESSING IN TOOL	
DWG NO. RBE105-42124W3-13	REV 1
MAT'L 4140/4142 HEAT TREAT RC 28-34 FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: RJC 06/27/2017 CHECKED: DD 06/27/2017 OPPS APPR: AA 07/10/2017 QA APPR: JL 07/10/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: JAG 07/19/2017	USED ON MODEL EC145, EC645, BO105, BK117
SCALE 1:1	DATE 6/27/2017
SHEET 8 OF 12	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



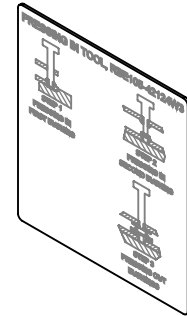
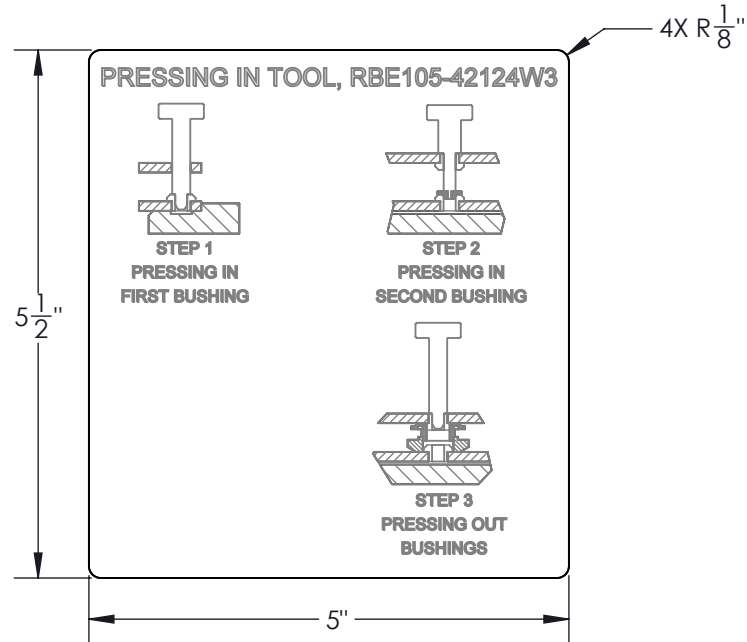
NOTES:
USE PDF.

(-15)
LOCATION PLACARD

DART AEROSPACE	
TITLE PRESSING IN TOOL	
DWG NO. RBE105-42124W3-15	REV 1
MAT'L PLASTIC HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: RJC 06/27/2017	USED ON MODEL
CHECKED: DD 06/27/2017	
OPPS APPR: AA 07/10/2017	
QA APPR: JL 07/10/2017	
APPROVED: JAG 07/19/2017	EC145, EC645, BO105, BK117
SCALE 1:2	DATE 6/27/2017
SHEET 9 OF 12	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



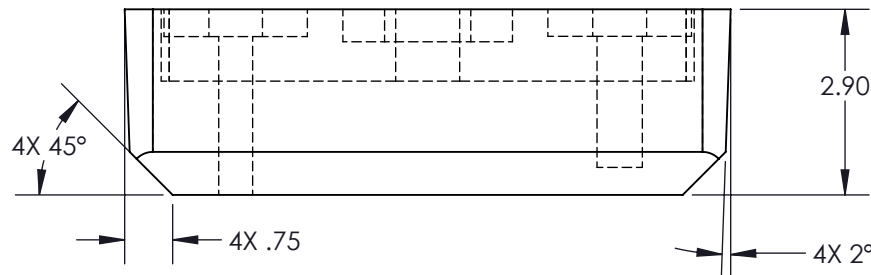
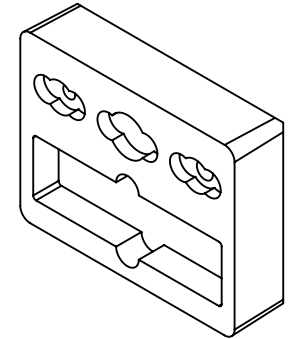
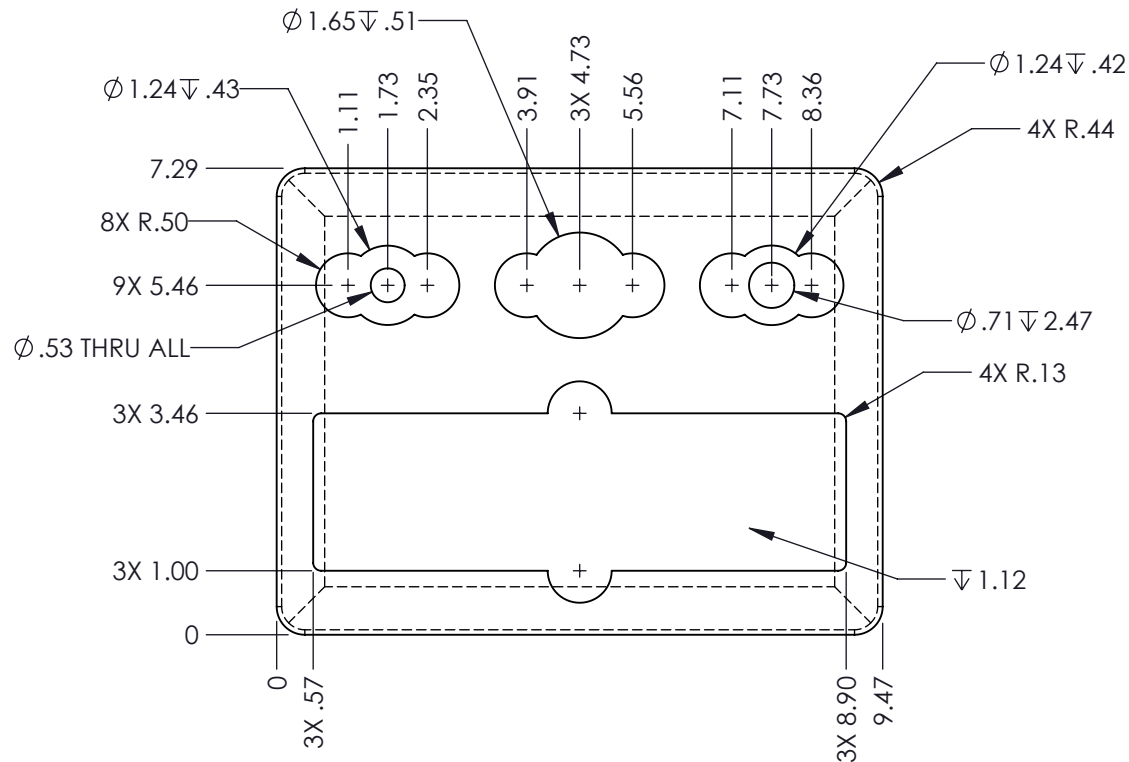
NOTE:
USE PDF.

-17
INSTRUCTION CARD

DART AEROSPACE	
TITLE PRESSING IN TOOL	
DWG NO. RBE105-42124W3-17	REV 1
MAT'L LAMINATED PAPER HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: RJC 06/27/2017	USED ON MODEL
CHECKED: DD 06/27/2017	
OPPS APPR: AA 07/10/2017	
QA APPR: JL 07/10/2017	
APPROVED: JAG 07/19/2017	EC145, EC645, BO105, BK117
SCALE 1:2	DATE 6/30/2017 SHEET 10 OF 12

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED

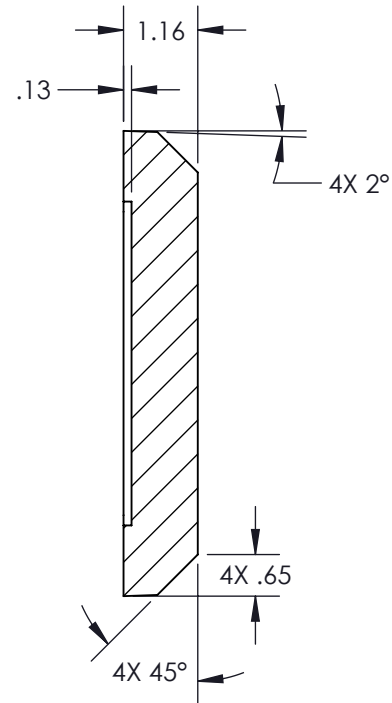
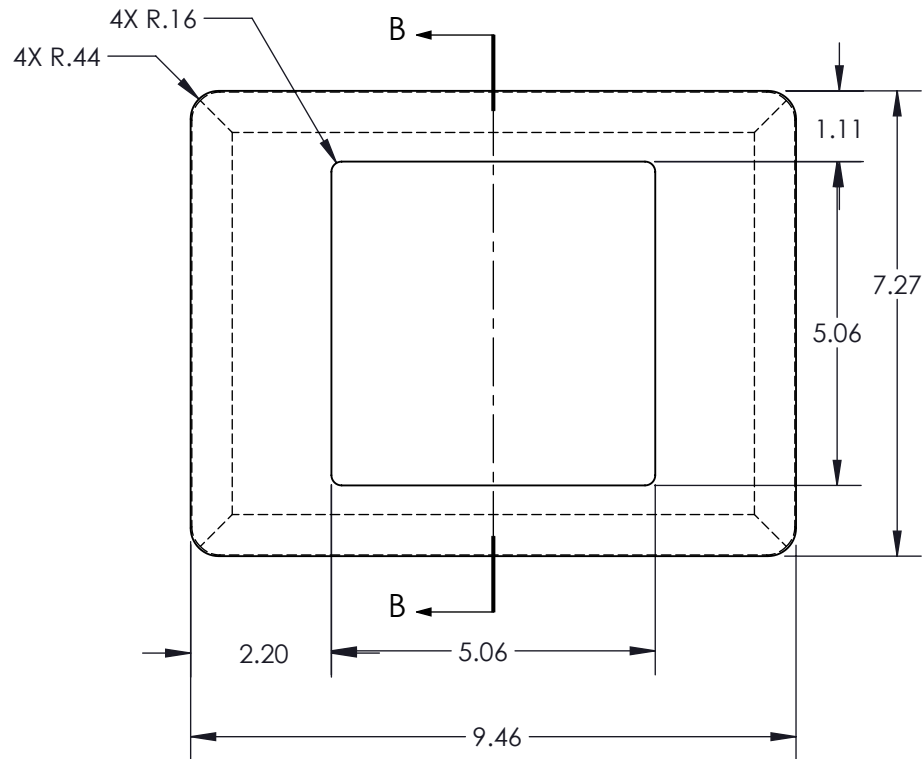


(-19)

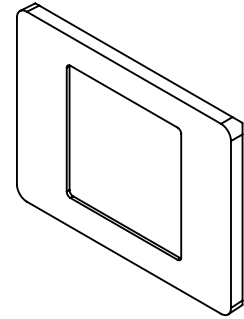
BOTTOM FOAM

DART AEROSPACE	
TITLE PRESSING IN TOOL	
DWG NO. RBE105-42124W3-19	REV 1
MAT'L ETHAFOAM 220, BLACK	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT FINISH	.XXX \pm .010 FRACTIONS \pm 1/8
	.XX \pm .03 ANGLES \pm 1°
	.X \pm .1 SURFACES = 125°
SPEC	
DRAWN BY: RJC 06/27/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 06/27/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/10/2017	USED ON MODEL
APPROVED: JAG 07/19/2017	EC145, EC645, BO105, BK117
SCALE 1:3	DATE 6/27/2017
SHEET 11 OF 12	

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SECTION B-B



(21)

TOP FOAM

TITLE		
PRESSING IN TOOL		
DWG NO.		REV
RBT105-42124W3-21		1
MAT'L ETHAFOAM 220, BLACK		UNLESS OTHERWISE SPECIFIED
HEAT		DIMENSIONS ARE IN INCHES
TREAT		.XXX ± .010 FRACTIONS ± 1/8
FINISH		.XX ± .03 ANGLES ± 1°
SPEC		.X ± .1 SURFACES = 125°
DRAWN BY: RJC 06/27/2017		1. BREAK ALL SHARP EDGES
CHECKED: DD 06/27/2017		.015 x 45° OR .015R
OPPS APPR: AA 07/10/2017		2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 07/10/2017		AFTER PLATING
APPROVED: JAG 07/19/2017		3. INTERPRET DIM AND TOL PER
SCALE 1:3		ASME Y14.5M-2009
DATE 6/27/2017		USED ON MODEL
SHEET 12 OF 12		EC145, EC645, BO105, BK117